

Work Order ID 110422

December-19-13 2:06:09 PM

110422

Page 1

Item ID: D3391-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mid Tube Assembly
 Start Date: 12/19/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/27/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MJS Date: 12-19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100 0.00
100 Skidtubes
 Skidtubes
 Skidtubes

Memo 0.00

- 1- Cut tube to finish length as per Dwg D3391
- 2- Identify as D3391-013
- 3- Drill pilot holes using DT8796 (including "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391
- 4- Open saddles and GHW holes to Ø0.375" except for fwd saddle hole of detail "J"
- 5- Remove .030" from Fwd indexing Ridge as per Dwg D3391
- 6- Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391
- 7- Deburr
- 8- Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,
- 9- Open wearplate holes of D3391-013 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391. DO NOT OPEN HOLES OF SECTION G-G
- 10- Open .375" holes to .438" ***do not open fwd saddle holes***
- 11- Locate electric step holes at 39.6875" from fwd end and drill using DT 9612

mm

14/01/07

PTC

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Item ID: D3391-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mid Tube Assembly

Start Date: 12/19/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/27/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

12- Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

13- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer drilled pilot holes in D3391-013/-011 to 0.438" dia. in D3391-011.
D3391-011 BATCH: 106150

14- Using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-011.

15- Locating from two fwd wearplate holes drill remaining 6 wearplte holes in D3391-011 using DT8937

16- Open 10 wearplate holes in D3391-011 to 0.297" dia.

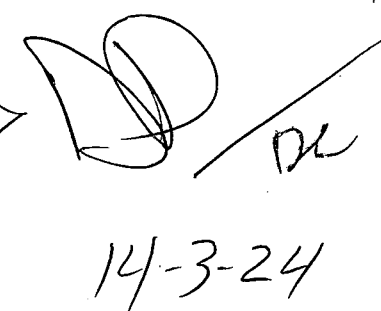
17- insert D3391-011 into D3391-13

18- insert T-pins into first and third fwd saddle holes

19- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per

20- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499".

21- Deburr and blow out all chips from inside tube, scribe batch # in D3391-013 at aft end.



14-3-24

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Item ID: D3391-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Mid Tube Assembly

Start Date: 12/19/13 Start Qty: 1.00

**

Cust Item ID:

Required Date: 12/27/13 Req'd Qty: 1.00

**

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

① 14-03-25

DAS
9
9-88

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

14-3-25 7/6

130

QC7-Inspect Chemical Conversion Coat

0.00

130

QC

Memo

0.00

Quality Control

14-3-25

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Item ID: D3391-013 Accept *N900040100* Setup Start *NS1*
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 Required Date: 12/27/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140		0.00							
-----	--	------	--	--	--	--	--	--	--

140

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Open holes to finish size as per dwg. DO NOT OPEN WEARPLATE HOLES OF SECTION G-G

2- Prepare for welding

3- Bond web in place as per Dwg D3391 & QSI 015.

*****Ensure Web Alignment *****

A/R Sikaflex Batch: 128 026

Exp. date: 14-10-9

- DC 14/03/25

14-3-25 JLL

14-03-26

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Quality Control

Memo

0.00

DAS
18
0-00

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Item ID: D3391-013 Accept ***N900040100*** Setup Start ***NS1***
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 Start Date: 12/19/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/27/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

160

Skidtubes

Skidtubes

Skidtubes

Memo

1-Weld crossbolt spacer as per dwg D3391 & QSI 004
 A/R ALUM Batch: 1127763

2-grind weld flush

3- Transfer drill electric step pilot holes only from D3391-013 into D3391-015
 D3391-013 BATCH: 111888

4- Open electric step holes 0.391" per dwg D3391 (section L-L)

5- Open electric step holes 0.297" per dwg D3391 (section M-M)

6- Open electric step holes 0.250" per dwg D3391 (section LL-LL)

7-Open wearplate holes of D3391-013 assembly detail section G-G to Ø0.250"
 (10 holes) as per Dwg D3391

QC10- Inspect visual per QSI004- ground welds

Memo

170

170

QC

Quality Control

DAS

27

11/14/13

0.00

Handwritten signature and date: 14-3-26

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Accept

N900040100

Setup Start *NS1*

Item Name: Mid Tube Assembly

Stop *NS2*

Start Date: 12/19/13 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 12/27/13 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

QC5- Inspect part completeness to step on W/O

0.00 DAS

180

OC

Memo

0.00

Quality Control

185

Pressure Wash per QSI005 4.3

0.00

185

HandFinish

Memo

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043

190

White Gloss(Ref:4.3.5.1), per QSI005 4.3-Alum

0.00

190

Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:05
OVEN TEMPERATURE: 300°
FINISH TIME: 3:05

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Item ID: D3391-013

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mid Tube Assembly

Start Date: 12/19/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/27/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC3- Inspect Part Finish	0.00							
200									
QC	Memo	0.00				1x	0	22	12/19/13
Quality Control									
230		0.00							
230	HandFinishing								
HandFinish	Memo	0.00				1x	0	22	12/19/13
Hand Finishing	1- press fit D3591-1 spacers using DT9416 starting from 0.500" side								
	2- Install inserts								
250		0.00							
250	HandFinishing								
HandFinish	Memo	0.00				1x	0	22	12/19/13
Hand Finishing	Assemble as per dwg D3391								

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Item ID: D3391-013 Accept *N900040100* Setup Start *NS1*
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 Start Date: 12/19/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/27/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC5- Inspect part completeness to step on W/O	0.00							
260									
QC	Memo	0.00							
Quality Control									
270	Identify as per dwg & Stock Location: <u>W/O</u>	0.00							
270									
Packaging	Memo	0.00							
Packaging									
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

DAS
27
8-39
MB/114

2412-742-0411 13115320

1x d ell 10/04/09

MLJ 1407-14

14-7-14

December-19-13 2:06:13 PM

1 10422

D3391-013

Start Date: 12/19/13**Required Date:** 12/27/13**Start Qty: 1.00**

Required Qty: 1.00

Comments: IPP A05.12.13New IssueEC
IPP B06.02.09Dwg rev.D EC
IPP Rev:06-03-28 Update Manufacturing Instructions JLMIPP rev D
07.03.14 dwg Rev F EC
IPP Rev:E ECN 1056 07-11-13 DD verified by: EC
IPP Rev:F 08-07-28 chg 0.332" to 0.391" dim. hole in comment DD verified
by:EC
IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC IPP rev J
10.03.30 revised process, added D3391-015 to pick list EC verified : DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3389-1		Manufactured	No				Each	4.0000					
<div> <div>*D3389-1*</div> <div>Web</div> <div> <div>B 113 057</div> <div> <div>Location</div> <div>LG002</div> <div>108410</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div> </div> <div> <div>**</div> <div>14-3-25 JCL/KP</div> </div> </div>													
NAS1149C0332R		Purchased	No				Each	9,647.000					
<div> <div>*NAS1149C0332R*</div> <div>WASHER</div> <div> <div>Location</div> <div>GA</div> <div>125654</div> <div>st510</div> <div>m126319</div> <div>m127306</div> <div>m127410</div> </div> <div> <div>Loc Qty</div> <div>1277</div> <div>1277</div> <div>8370</div> <div>2870</div> <div>2500</div> <div>3000</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> </div> </div> <div> <div>**</div> <div> <div>4</div> <div>4</div> </div> <div> <div>4</div> <div>4</div> </div> </div>													

Picklist Print

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Page 2

Work Order ID: 110422

110422

Parent Item: D3391-013

D3391-013

Parent Item Name: Mid Tube Assembly

Start Date: 12/19/13

Required Date: 12/27/13

Start Qty: 1.00

Required Qty: 1.00

D2500-1-100

Manufactured No

100

Each

90.0000

1

1

D2500-1-100

Skidtube Extrusion

**

mm 12/12/19

Location

Loc Qty

Loc Code

HALL

90

82373

28

86065

62

MS27039C4-08

Purchased No

100

Each

144.0000

4

MS27039C4-08

SCREW

**

12/12/19

Location

Loc Qty

Loc Code

ST308

144

m126319

144

D3681-1

Manufactured No

160

Each

245.0000

12

12

D3681-1

Spacer

**

12/14/03-2.5

Location

Loc Qty

Loc Code

LG001

269

102202

44

108647

65

109109

136

ALS4-428-165

Purchased No

230

Each

187.0000

4

4

ALS4-428-165

INSERT

**

12/14/04

Location

Loc Qty

Loc Code

FG

10

117769

10

FP001

177

117769

177

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 110422

110422

Parent Item: D3391-013

D3391-013

Parent Item Name: Mid Tube Assembly

Start Date: 12/19/13

Required Date: 12/27/13

Start Qty: 1.00

Required Qty: 1.00

D3591-1

Manufactured No

230

Each

106.0000

2

2

D3591-1

Bushing

Location

Loc Qty

Loc Code

FG

10

92873

10

FP001

96

100699

15

107918

40

109107

41

M121446

✓2

ALS4-1032-130

Purchased No

250

Each

2,255.000

26

26

ALS4-1032-130

Rivnut

Location

Loc Qty

Loc Code

st510

1917

M126109

1917

st555

338

M127028

338

M128649

✓26

D3672-1

Manufactured No

250

Each

938.0000

4

4

D3672-1

Phenolic Washer

Location

Loc Qty

Loc Code

FG

10

85222

10

ST060

928

103845

136

93886

522

99099

270

✓4

Picklist Print

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Work Order ID: 110422

110422

Parent Item: D3391-013

D3391-013

Parent Item Name: Mid Tube Assembly

Start Date: 12/19/13

Required Date: 12/27/13

Start Qty: 1.00

Required Qty: 1.00

D3672-3

Manufactured No

250

Each

334.0000

4

4

D3672-3

Phenolic Washer

lll 11/04/13

Location

Loc Qty

Loc Code

FG

111

84432

11

89273

100

FP001

87

107316

87

ST061

136

93925

136

X4

MS27039C1-09

Purchased

No

250

Each

48.0000

4

4

MS27039C1-09

Screw

lll 11/04/13

Location

Loc Qty

Loc Code

ST309

48

116290

48

v4

NAS1149C0432R

Purchased

No

250

Each

5,372.000

4

4

NAS1149C0432R

WASHER

lll 11/04/13

Location

Loc Qty

Loc Code

GA

2093

m125807

2093

ST292

68

119124

6

121255

7

121825

8

122441

55

ST510a

3211

m126221

3211

X4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

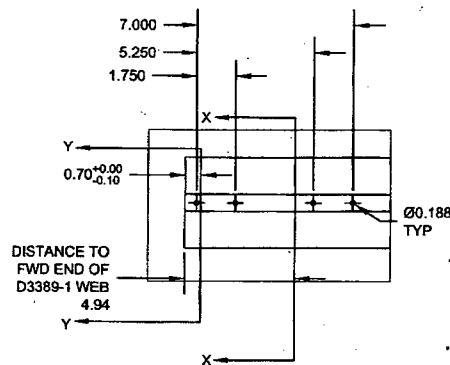
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

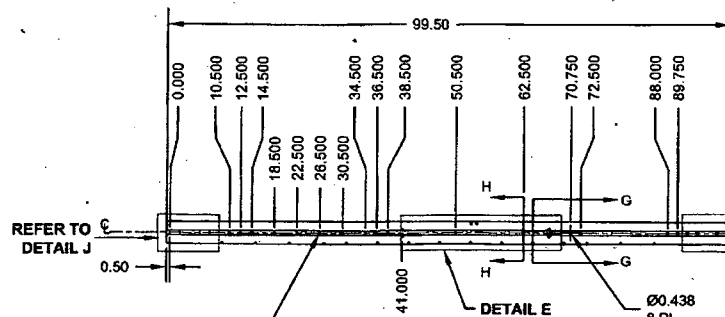
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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110422
MCS
13-12-19



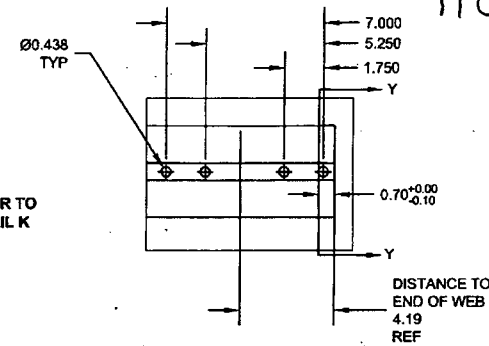
DETAIL J
SCALE 4X

DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



D3391-013 ASSEMBLY DETAIL

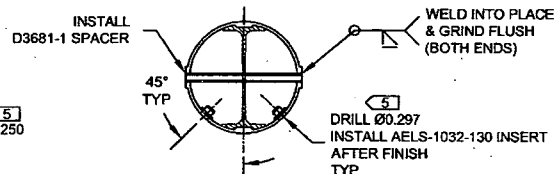
REFER TO
DETAIL K



DETAIL K
SCALE 4X

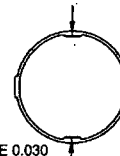


SECTION G-G
SCALE 5X

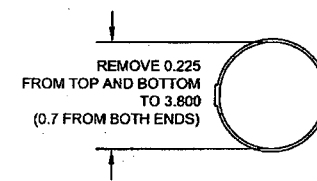


SECTION H-H
SCALE 5X

REMOVE 0.030
FROM TOP AND BOTTOM
TO 3.610

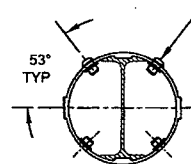


SECTION X-X
SCALE 5X

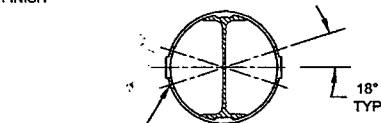


SECTION Y-Y
SCALE 5X

DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL



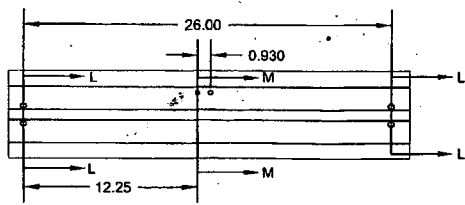
SECTION M-M
SCALE 5X



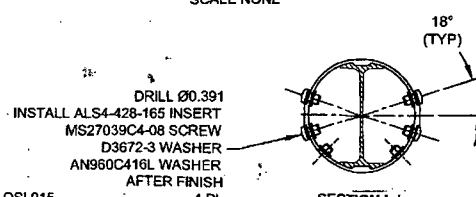
SECTION LL-LL
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



DETAIL E
SCALE NONE



SECTION L-L
SCALE 5X

D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

RELEASED
11/2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO. D3391	REV. 1
MFG. APPR.		SHEET 5 OF 8	
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DQA:

Date: 14/08/01



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 14/7/14

Work Order update only ☐

Work Order: <u>110422</u> Part No: <u>3391-013</u> NCR No. <u>14-4030</u>	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS Skid-tube <input checked="" type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process <input checked="" type="checkbox"/> Supplier Training Transport Unapproved	14/3/20	100	1	There were drill marks on bottom of tube (tool slipped). Tube Tube was buffed. Min wall was 0.088 0.088 in one location (dwg min = 0.090)	14/3/20 	Acceptable. Well is 0.002 under tol. in one small area not in area of highest stress.	 14/3/20	DAS 9-89 1403-25	DAS 27 9-89 14/7/14

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input checked="" type="checkbox"/> Other
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pmc

NO. 334

**AWS D17.1.2001
QUALIFICATION TEST RECORD**

Name: Barclay Elliot
Job #: 108635
Part #: 3391-023
Description: Skid Plate
Welding Process: Tig[☒] Mig[☐]
Base material: Alum
Current: AC[☒] DC[☐]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[<input checked="" type="checkbox"/>]	fail[<input type="checkbox"/>]
Incomplete Penetration:	pass[<input checked="" type="checkbox"/>]	fail[<input type="checkbox"/>]
Incomplete Fusion:	pass[<input checked="" type="checkbox"/>]	fail[<input type="checkbox"/>]
Cracks:	pass[<input checked="" type="checkbox"/>]	fail[<input type="checkbox"/>]
Overlap (cold lap)	pass[<input checked="" type="checkbox"/>]	fail[<input type="checkbox"/>]
Undercut:	pass[<input checked="" type="checkbox"/>]	fail[<input type="checkbox"/>]
Pin holes:	pass[<input checked="" type="checkbox"/>]	fail[<input type="checkbox"/>]
Porosity (surface):	pass[<input checked="" type="checkbox"/>]	fail[<input type="checkbox"/>]
Coloration:	pass[<input checked="" type="checkbox"/>]	fail[<input type="checkbox"/>]
Burn through:	pass[<input checked="" type="checkbox"/>]	fail[<input type="checkbox"/>]

Qualifier [Signature] Date of Test Coupon 13.10.25

Welder Barclay Elliot Date of Test Coupon 13-10-25

The above named individual is qualified in accordance with AWS D17.1.2001 to weld